



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE332A94-3400-03-9

Job Sheet 203816



Part No: RBE332A94-3400-03-9

Job Qty: 2 pcs

Part Name: Sight Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/27/19

Job Tracking No:

Due Date: 12/13/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE332A94-3400-03 Rev A IPP Rev. A 19.02.19 New issue DP Verify DD
Ship Via:



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S240792



Part: RBE332A94-3400-03-9

Job No: 203816

Serial No/Batch: S240792

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 12/16/19

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	12/13/19	0.00	0.40	Small Fab - 1		MLL	
						Small Fab - 2			
						Small Fab - 3			
						Small Fab - 4			
						Small Fab - 5			
						Small Fab - 6			
						Small Fab - 7			
						Small Fab - 8			
						Small Fab - 9			
110	QC 5	2 pcs	12/13/19	0.00	0.00	QC 5 - 10		DAS 40 DEC 16 2019 9-89	
						QC 5 - 12			
						QC 5 - 17			
						QC 5 - 18			
						QC 5 - 19			
						QC 5 - 22			
						QC 5 - 24			
						QC 5 - 3			
						QC 5 - 43			
						QC 5 - 49			
						QC 5 - 51			
						QC 5 - 58			
						QC 5 - 68			
						QC 5 - 9			
						QC 5 - 50			
						QC 5 - 30			
						QC 5 - 40			
						QC 5 - 61			
						QC 5 - 81			
120	Packaging 3-1 - Stock - B4B	2 pcs	12/13/19	0.00	0.00	Packaging 3 - 1 - B4B		MLL	
						Packaging 3 - 2 - B4B			
						Packaging 3 - 3 - B4B			
						Packaging 3 - 4 - B4B			
						Packaging 3 - 5 - B4B			
						Packaging 3 - 6 - B4B			
						Packaging 3 - 7 - B4B			
						Packaging 3 - 8 - B4B			
						Packaging 3 - 9 - B4B			
						Packaging 3 - 10 - B4B			
130	QC 21 - FG	2 pcs	12/13/19	0.00	0.00	QC 21 - FG - 21		DAS 21 9-89 DEC 16 2019	
						QC 21 - FG - 70			
						QC 21 - SA - 53			

Part Op 100 - Assemble as per DWG. See note 8.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.
 130 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
65 90591A161	Hex Nut M8 x 1.25	6 Ea (3 ea)	100-Small Fab - 1	FM138914-7
67 91166A270	Washer, M8	6 Ea (3 ea)	100-Small Fab - 1	8116853
70 91280A550	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M8 X 1.25 mm X 60 mm LG.	6 Ea (3 ea)	100-Small Fab - 1	518-7240
58 96445K241	STEEL BELLEVILLE DISC SPRING 9.2 mm ID. X 18 mm OD. X 1 mm THK.	24 Ea (12 ea)	100-Small Fab - 1	5236572
1408 RBE332A94-3400-03-10	Block	2 pcs (1 ea)	100-Small Fab - 1	5168924
RBE332A94-3400-03-11	Support	2 pcs (1 ea)	100-Small Fab - 1	5218611

13479

Job Allocations

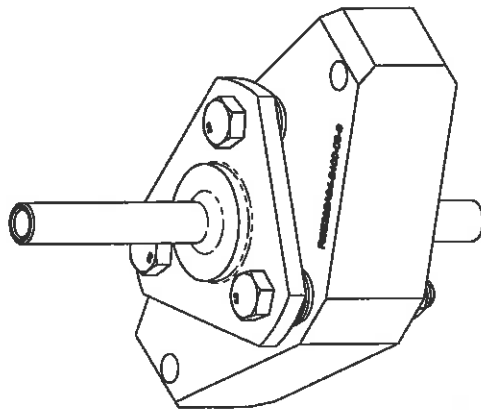
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90591A161	6	54	0
	91166A270	6	101	0
	91280A550	6	12	0
	96445K241	24	12	0
	RBE332A94-3400-03-10	2	7	0
	RBE332A94-3400-03-11	2	6	0

Part Specifications

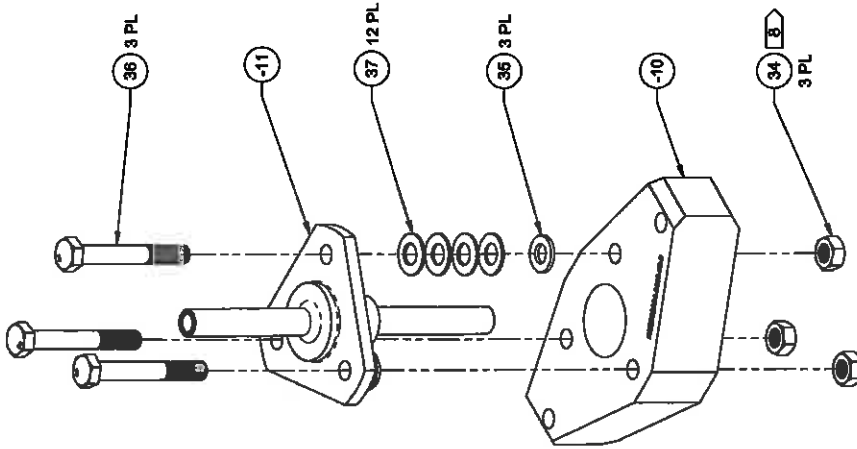
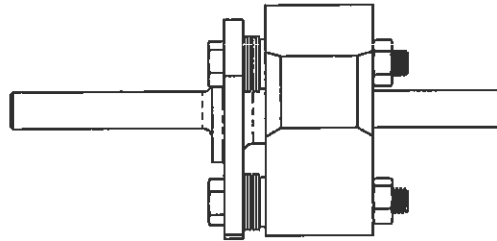
Specifications could not be found.

Plex 11/27/19 1:25 PM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-10	1	RBE332A94-3400-03-10	BLOCK
-11	1	RBE332A94-3400-03-11	SUPPORT
34	3	McMaster#90991A161 OR EQUIV.	ZINC PLATED CLASS 8 STEEL HEX NUT M8 X 1.25 mm X 8.5 mm HT.
36	3	McMaster#91168A270 OR EQUIV.	ZINC PLATED STEEL WASHER 8.4 mm ID. X 18 mm OD. X 1.4 mm-1.8 mm THK.
36	3	McMaster#91200A550 OR EQUIV.	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M8 X 1.25 mm X 60 mm LG.
37	12	McMaster#98444K241 OR EQUIV.	STEEL BELLEVILLE DISC SPRING 9.2 mm ID. X 18 mm OD. X 1 mm THK.



RBE332A94-3400-03-9 SIGHT SUPPORT



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: XX = $\pm 0.1"$ / $\pm 1"$
XX = $\pm 0.01"$ / $\pm 0.5"$
XXX = $\pm 0.005"$ / $\pm 0.1"$
XXXX = $\pm 0.0005"$ / $\pm 0.06"$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS NOTED

IDENTIFICATION: N/A

ASSEMBLY: N/A

INSTALL ITEM 34 HAND TIGHT

THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 2038160
19-A-27

DESIGN DRAWN	CHECKED	MFG. APPR.	APPROVED	DATE
				2/14/2019

REV. A	SHEET 10 OF 28	SCALE	NTS
DART AEROSPACE LTD HAMILTON, ONTARIO, CANADA			
TOOL PART # RBE332A94-3400-03			
TITLE T/R DRIVE ALIGNMENT INSPECTION			

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				DEPARTMENT/PROCESS		MRB (QSI042)	
Date :	Sequence #:	QTY Affected :							
Description Work Order Deviation		Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		FAULT CATEGORY							
Completed By		QC / QA Coordinator							
Lead hand / Supervisor		QC / QA Coordinator							